

## Process Sheet

Split  
WLO 807/08/27 26

|                       |  |                           |                  |                      |  |          |
|-----------------------|--|---------------------------|------------------|----------------------|--|----------|
| Customer              | CU-DAR001  | Dart Helicopters Services | Drawing Name     | : PEDAL ASSEMBLY     |  |          |
| Job Number            | 32814  |                           | Part Number      | : D412704041         |  |          |
| Estimate Number       | 11005  |                           | Drawing Number   | : D412-704-041 REV A |  |          |
| P.O. Number           | N/A  |                           | Project Number   | : N/A                |  |          |
| This Issue            | 6/6/2007   | S.O. No. : N/A            | Drawing Revision | : A                  |  |          |
| Next Rev.             | NC   |                           | Material         | : N/A                |  |          |
| First Issue           | N/A  | Type : SMALL /MED FAB     | Due Date         | : 6/26/2007          |  |          |
| Previous Run          | 29896  |                           | Qty:             | 1                    |  |          |
| Written By            |  |                           |                  |                      |  | Um: Each |
| Checked & Approved By |  |                           |                  |                      |  | PTO      |
| Comment               | Est Rev:B 05.01.28 Removed hardware on Step 2; Added Figures 1-3 KJ/RF |                           |                  |                      |  |          |
|                       | Est Rev:C 06.03.08 Re-format EC  |                           |                  |                      |  |          |
|                       | Est Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20                     |                           |                  |                      |  |          |
|                       | JLM  |                           |                  |                      |  |          |
|                       | Est Rev:E 07.05.02 Reformat EC   |                           |                  |                      |  |          |

Additional Product

Job Number



| Seq #:   | Machine Or Operation: |                     | Description:   |                |                    |
|----------|-----------------------|---------------------|----------------|----------------|--------------------|
| 10       | D3204041              |                     | Pedal Assembly |                |                    |
|          |                       |                     |                |                |                    |
| Comment: | Qty:                  | 1.0000 Each(s)/Unit | Total:         | 6.0000 Each(s) |                    |
| Pick:    |                       |                     |                |                |                    |
| Qty      | Part number           | Description         | batch          | X 1            |                    |
| 1        | D3204-041             | Pedal Assembly      | B 30829        | X 5            | <i>ml</i>          |
| 20       | D32051                |                     | Bracket        |                |                    |
|          |                       |                     |                |                |                    |
| Comment: | Qty:                  | 1.0000 Each(s)/Unit | Total:         | 6.0000 Each(s) |                    |
| Pick:    |                       |                     |                |                |                    |
| Qty      | Part number           | Description         | batch          | B 30830 X 4    | <i>ml</i>          |
| 1        | D3205-1               | Bracket             | B 38941        | X 2            |                    |
| 30       | D32053                |                     | Back Plate     |                |                    |
|          |                       |                     |                |                |                    |
| Comment: | Qty:                  | 1.0000 Each(s)/Unit | Total:         | 6.0000 Each(s) |                    |
| Pick:    |                       |                     |                |                |                    |
| Qty      | Part number           | Description         | batch          | B 28742 X 1    | <i>ml</i>          |
| 1        | D3205-3               | GHW Bracket         |                |                |                    |
| 40       | D32061                |                     | Pedal Arm      |                |                    |
|          |                       |                     |                |                |                    |
| Comment: | Qty:                  | 1.0000 Each(s)/Unit | Total:         | 6.0000 Each(s) |                    |
| Pick:    |                       |                     |                |                |                    |
| Qty      | Part number           | Description         | batch          | B 29915 X 6    | <i>ml 07/08/27</i> |
|          |                       |                     |                |                |                    |

| W/O:     |      | WORK ORDER CHANGES |    |          |     |                                     |                          |
|----------|------|--------------------|----|----------|-----|-------------------------------------|--------------------------|
| DATE     | STEP | PROCEDURE CHANGE   | By | Date     | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
| 07/03/27 | 15   | Split u/o          | BS | 07/03/27 | 1   |                                     |                          |
|          |      |                    |    |          |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 32814

Part Number: D412704041

Job Number:



| Seq. # | Machine Or Operation:              |                         |             | Description :                            |
|--------|------------------------------------|-------------------------|-------------|--|
| 1      | D3206-1                            | Pedal arm               | _____       |  |
| 6.0    | AN310A                             | Bracket                 |             |  |
|        | Comment: Qty.: 1.0000 Each(s)/Unit | Total : 6.0000 Each(s)  |             |  |
|        | Pick:                              |                         |             |  |
|        | Qty                                | Part number             | Description | batch                                    |
|        | 1                                  | D3209-.041              | Bracket     | <u>B 23194 X 2</u><br><u>B 30832 X 4</u> |
| 6.1    | AN310A                             | Bolt                    |             |  |
|        | Comment: Qty.: 1.0000 Each(s)/Unit | Total : 6.0000 Each(s)  |             |  |
|        | Pick:                              |                         |             |  |
|        | Qty                                | Part number             | Description | batch                                    |
|        | 1                                  | AN3-10A                 | Bolt        | <u>M17566</u>                            |
| 6.2    | AN3154R                            | Nut                     |             |  |
|        | Comment: Qty.: 1.0000 Each(s)/Unit | Total : 6.0000 Each(s)  |             |  |
|        | Pick:                              |                         |             |  |
|        | Qty                                | Part number             | Description | batch                                    |
|        | 1                                  | AN315-4R                | Nut         | <u>M17566</u>                            |
| 6.3    | AN410A                             | Bolt                    |             |  |
|        | Comment: Qty.: 1.0000 Each(s)/Unit | Total : 6.0000 Each(s)  |             |  |
|        | Pick:                              |                         |             |  |
|        | Qty                                | Part number             | Description | batch                                    |
|        | 1                                  | AN4-10A                 | Bolt        | <u>M101291</u>                           |
| 6.4    | AN412A                             | Bolt                    |             |  |
|        | Comment: Qty.: 2.0000 Each(s)/Unit | Total : 12.0000 Each(s) |             |  |
|        | Pick:                              |                         |             |  |
|        | Qty                                | Part number             | Description | batch                                    |
|        | 2                                  | AN4-12A                 | Bolt        | <u>M104547</u>                           |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 2:01:53 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

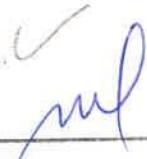
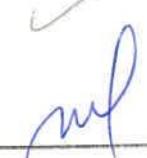
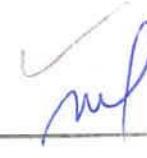
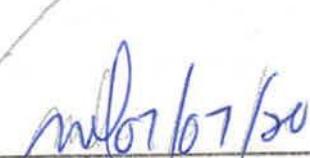
Drawing Name: PEDAL ASSEMBLY

Job Number: 32814

Part Number: D412704041

Job Number:



| Seq. #: | Machine Or Operation: | Description:  |                         |   |
|---------|-----------------------|---|-------------------------|---|
| 100     | AN413A                | Bolt  |                         |    |
|         |                       | Comment: Qty: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)   |                         |    |
|         |                       | Pick:   |                         |   |
|         |                       | Qty: 1  | Part number AN4-13A     | Description: batch <u>M104746</u>   |
| 110     | AN960JD10             | Washer  |                         |    |
|         |                       | Comment: Qty: 5.0000 Each(s)/Unit Total: 30.0000 Each(s)  |                         |    |
|         |                       | Pick:   |                         |   |
|         |                       | Qty: 5  | Part number AN960JD10   | Description: batch <u>M104885</u>   |
| 120     | AN960JD416            | Washer  |                         |   |
|         |                       | Comment: Qty: 11.0000 Each(s)/Unit Total: 66.0000 Each(s) |                         |  |
|         |                       | Pick:   |                         |   |
|         |                       | Qty: 11   | Part number AN960JD416  | Description: batch <u>M104215</u>   |
| 130     | AN960JD416L           | Washer  |                         |  |
|         |                       | Comment: Qty: 3.0000 Each(s)/Unit Total: 18.0000 Each(s)  |                         |  |
|         |                       | Pick:   |                         |   |
|         |                       | Qty: 3  | Part number AN960JD416L | Description: batch <u>M104214</u>   |
| 140     | MS21042L3             | Nut   |                         |  |
|         |                       | Comment: Qty: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)   |                         |  |
|         |                       | Pick:   |                         |   |
|         |                       | Qty: 1  | Part number MS21042L3   | Description: batch <u>M103830</u>   |
| 150     | MS21042L4             | Nut   |                         |  |
|         |                       | Comment: Qty: 5.0000 Each(s)/Unit Total: 30.0000 Each(s)  |                         |  |
|         |                       | Pick:   |                         |   |
|         |                       | Qty: 5  | Part number MS21042L4   | Description: batch <u>M102552</u>   |

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 32814

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description:

16.0 MS24694S102

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

| Qty | Part number | Description | batch         |
|-----|-------------|-------------|---------------|
| 1   | MS24694S102 | Screw       | <u>M14604</u> |



✓ ml

17.0 MS951910

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

| Qty | Part number | Description | batch          |
|-----|-------------|-------------|----------------|
| 1   | MS9519-10   | Bolt        | <u>M100290</u> |



✓ ml 07/07/20

18.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



~~ml~~

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble pedal as per Dwg D412-704-041

Tighten & Torque Bolts as per Dwg D412-704-041

ml 07/08/27 x1

19.0 Q05

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/27 (T)

20.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

21.0 AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

| Qty | Part number | Description | batch           |
|-----|-------------|-------------|-----------------|
| 4   | AN960JD10L  | Washer      | <u>M103044-</u> |

M103044-

✓ 07/08/27

to: Wednesday, 6/6/2007 2:01:52 PM  
aer: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL ASSEMBLY

Job Number: 32814

Part Number: D412704041

Job Number:



Seq. #:

Machine Or Operation:

Description:

220

AN36A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty  
2

Part number  
AN3-6A

Description  
Bolt

batch  
M100184 -



221

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut  
Batch:

M104936 -



EPL07/08/270

222

QC4

INSPECT 100% KITS FOR COMPLETENESS



EPL07/08/270

Comment: INSPECT 100% KITS FOR COMPLETENESS

223

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location:

EPL07/08/270

224

QC21

FINAL INSPECTION/W/O RELEASE



①

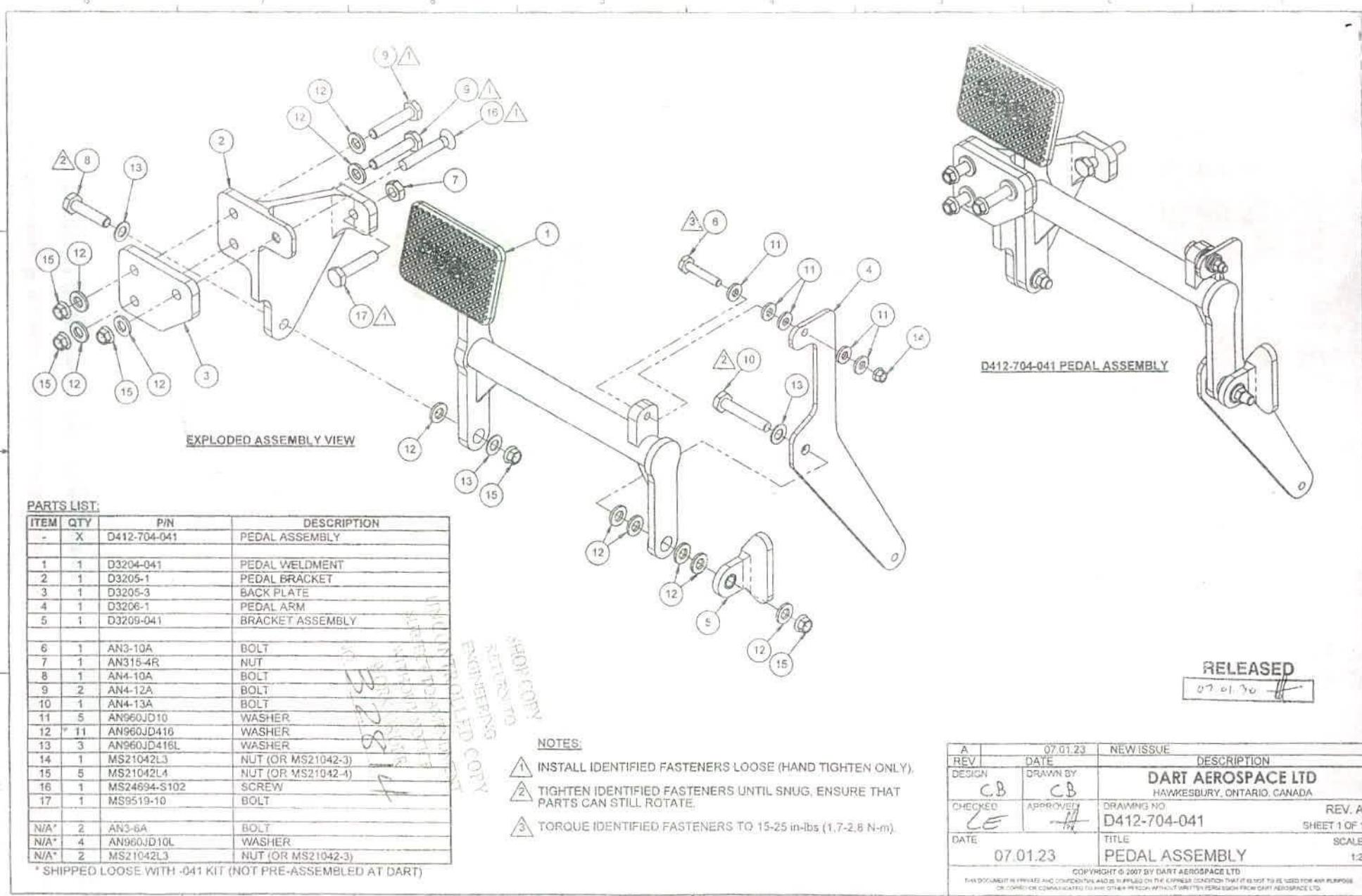
Comment: FINAL INSPECTION/W/O RELEASE

EPL07/08/280

Completion



U 8.08.28



| A       | 07.01.23 | NEW ISSUE | DESCRIPTION                                       |
|---------|----------|-----------|---|
| REV.    | DATE     | DRAWN BY  | APPROVED  |
| DESIGN  | CB       | CB        | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED | CE       | APPROVED  | DRAWING NO.<br>D412-704-041                       |
| DATE    | 07.01.23 | SCALE     | REV. A<br>SHEET 1 OF 1                            |
|         |          |           | TITLE<br>PEDAL ASSEMBLY                           |

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